

Date: Monday, 1/14/2008 1:25:27 PM
User: Chantal Lavoie

Process Sheet

| | | | |
|------------------------------------|---|---------------------------|-------------------------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | DOUBLER |
| Job Number : | 36762 | | |
| Estimate Number : | 11473 | | |
| P.O. Number : | N/A | Part Number : | D3140301 |
| This Issue : | 1/14/2008 | S.O. No. : | N/A |
| Prsht Rev. : | NC | Drawing Number : | D3140 REV F |
| First Issue : | 1/14/2008 | Project Number : | N/A |
| Previous Run : | 34381 | Drawing Revision : | F |
| | Type : | Material : | N/A |
| | SMALL /MED FAB | Due Date : | 1/16/2008 |
| Written By : | | | Qty: 3 Um: Each |
| Checked & Approved By : | | | |
| Comment : | Est. rev A 02.11.06 New issue KJ/RF Est. Rev B 06.04.18 New dwg rev. ecn781 EC EST rev.C 06.04.25 Waterjet EC Est. rev.D added scuffing NCR 061 EC Est Rev:E As per ECN #829 06-11-20 JLM | | |

Additional Product

Job Number: 

| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|-------------|--------------------|
| 1.0 | M6061T6S063 | 6061-T6 .063 Sheet |
|-----|-------------|--------------------|



Comment: Qty.: 2.9166 sf(s)/Unit Total : 8.7498 sf(s)
 Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063)
 Batch: 105225 IB 8-1-14

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
 1-Cut as per Dwg D 3140
 Dwg Rev: F IB 8-1-14
 Prog Rev: F

3

2-Deburr if necessary IB 8-1-14

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

08/01/14 (43)

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 36762

Part Number: D3140301

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Scuff surfaces with 80grit sandpaper per QSI 006

2-Deburr.

No sharp edges

JS 08/01/15 (3)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JS 08/01/15 (x3)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.L. 08/01/15

(3x)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

JS 08/01/15 (x3)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

JS 08/01/15 (3)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



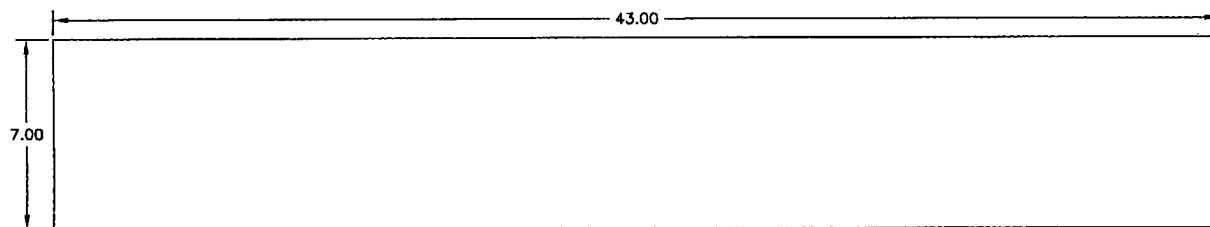
Comment: FINAL INSPECTION/W/O RELEASE



JS 08/01/16 (3)

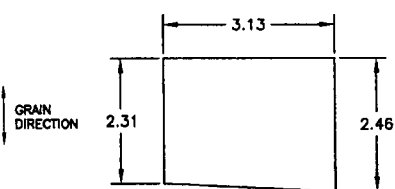
Job Completion



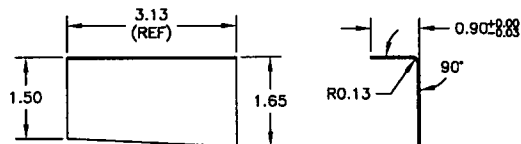
JS 08-01-16






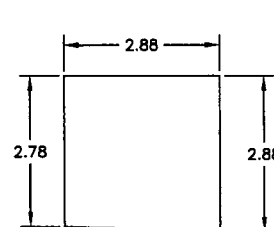
D3140-87 DOUBLER  
(REPLACES PREMIER P/N B30-23000-87)



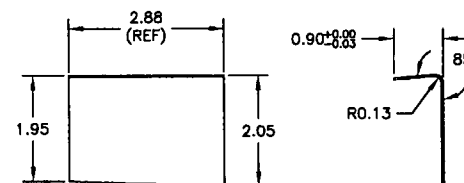
D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)







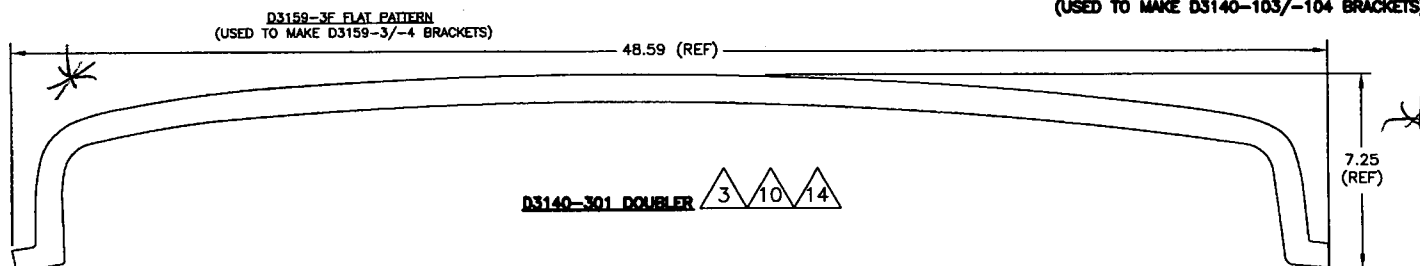
D3140-105 DOUBLER   
D3140-106 OPPOSITE



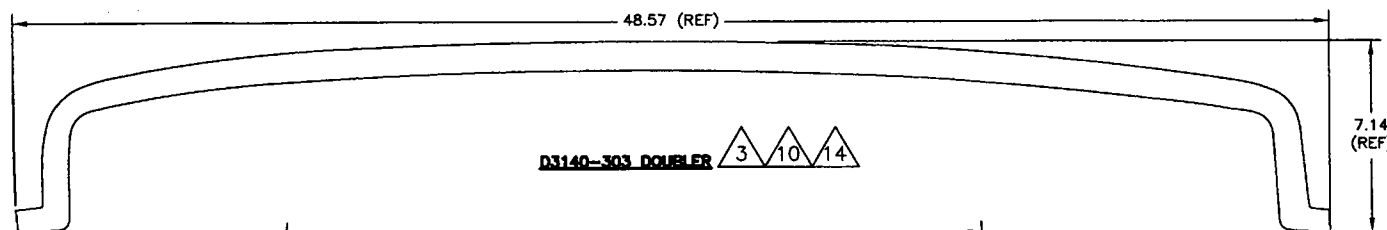
D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)



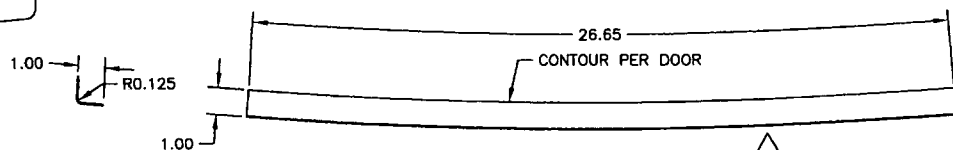
D3140-104 DOUBLER    
D3140-103 OPPOSITE




D3140-301 DOUBLER   






D3140-303 DOUBLER   



D3140-85 ANGLE 
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

RELEASED

06.11.13

| | | | | | |
|---|--|--|--------------------|--------------|--|
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| CHECKED  | APPROVED  | DRAWING NO. D3140 | | REV. F | |
| DATE 06.10.06 | TITLE DOOR | SHEET 6 OF 7 | | SCALE NTS | |

D10: 36762 C208/01/14

